

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT TUBE ASSEMBLY
Job Number	: 35776		
Estimate Number	: 10699		
P.O. Number	: N/A	Part Number	: D3391025
This Issue	: 11/15/2007 S.O. No. : N/A	Drawing Number	: D3391 REV G
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: G
Previous Run	: 35775	Material	: N/A
Written By	: _____	Due Date	: 12/10/2007 Qty: 1 UoM: Each
Checked & Approved By	: _____		
Comment	: Est Rev B 06-02-07 ECN773 dwg rev. D EC Est Rev:C 06-03-28 Update Manuf. Instructions JLM		
	est rev D 07.03.20 revF dwg EC		
	est rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD		
	Est Rev:F 07-11-13 ECN 1056 DD verified by: EC		

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6014090	ALUMINUM EXTRUSION
-----	----------	--------------------



**Comment:** Qty.: 1.0000 f(s)/Unit      Total : 1.0000 f(s)

## ALUMINUM EXTRUSION

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1 D6014-090 Extrusion B 26546

Identify as D3391-3

J.F. 07/11/23

20 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: G

J.F. 07/11/23 (1)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/11/23 (1)

---

40	HAAS1	HAAS CNC VERTICAL MACHINING #1
----	-------	--------------------------------



Comment: HAAS

1-Machine as per Folio FA 599 Rev: A4 & Dwg D3391 Rev: G

2-Deburr

36 02.12.05 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/15/2007 1:26:37 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 35776

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BG 02.12.05

①

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Cmk 02/12/05

①

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

EL 7-12-5

8.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

EL 7-12-5

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 7-12-6

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) &amp; DT8217 Wearplate Jig .

\*\*\*\*\*Do Not Open To Finished Size\*\*\*\*\*

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open up all wearshoe , wearplate and float bag holes as per Dwg D3391.

6-Deburr

Tools: rill

7-12-7

7-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/15/2007 1:26:37 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 35776

Part Number: D3391025

Job Number:



Seq. #: Machine Or Operation: Description :

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 7/12/17 (X)

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Acid etch and Alodine as per QSI 005 4.1

DP 7-12-17

13.0 D36704200 SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
SPACER  
batch: B35813

DP 7-12-17

14.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1  
Instal spacers as per dwg D3391

A/R Magnabond 6398 Batch: M105379

DP 7-12-17

15.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 7/12/19 (X)

16.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M105914

FL 7/12/19 (P)

17.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 7/12-19 (2)

18.0 D2646 Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Aft Cap  
Pick:  
Qty Part Number Description Batch  
1 D2646 Aft Cap

B32427 BL

BL 7/12-20 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/15/2007 1:26:37 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 35776

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D35371

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARPAD *B33696*

*BR*

20.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Wearpad *B33869*

*BR*

21.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Gasket *B31630*

*BR*

22.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Gasket *B32745*

*BR*

23.0

D36721

PHENOLIC WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
PHENOLIC WASHER *B34470*

*BR*

24.0

AELS1032130

INSERT

*\**



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)  
INSERT  
batch: *M105729*

*BR*

25.0

AELS1032225

INSERT

*\**



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)  
INSERT *M100489*

*BR*

26.0

AN3C4A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Bolt  
Pick:  
Qty Part Number Description Batch  
2 AN3C4A Bolt *M100431*

*BR*

*BR 07-12-20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: AD Date: 28/01/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Thursday, 11/15/2007 1:26:37 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 35776

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

M 106 552

BR

28.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Inventory

Pick:

Qty

Part Number Description

Batch

2

AN960C10L

Washer

M 106 575

BR

29.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/ R Sikaflex-241/-291

Sikaflex expiry date:

M 105585

08-07

BR

07-12-19 ①

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PP

357744

8/1/1550 ②

32.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 08/11/16

Job Completion



W 08.01.15

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	35776
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b>	D3391-3
<b>Inspection Dwg:</b> D3391		<b>Rev:</b> FG Pk 07-11-16	<b>Page 1 of 1</b>

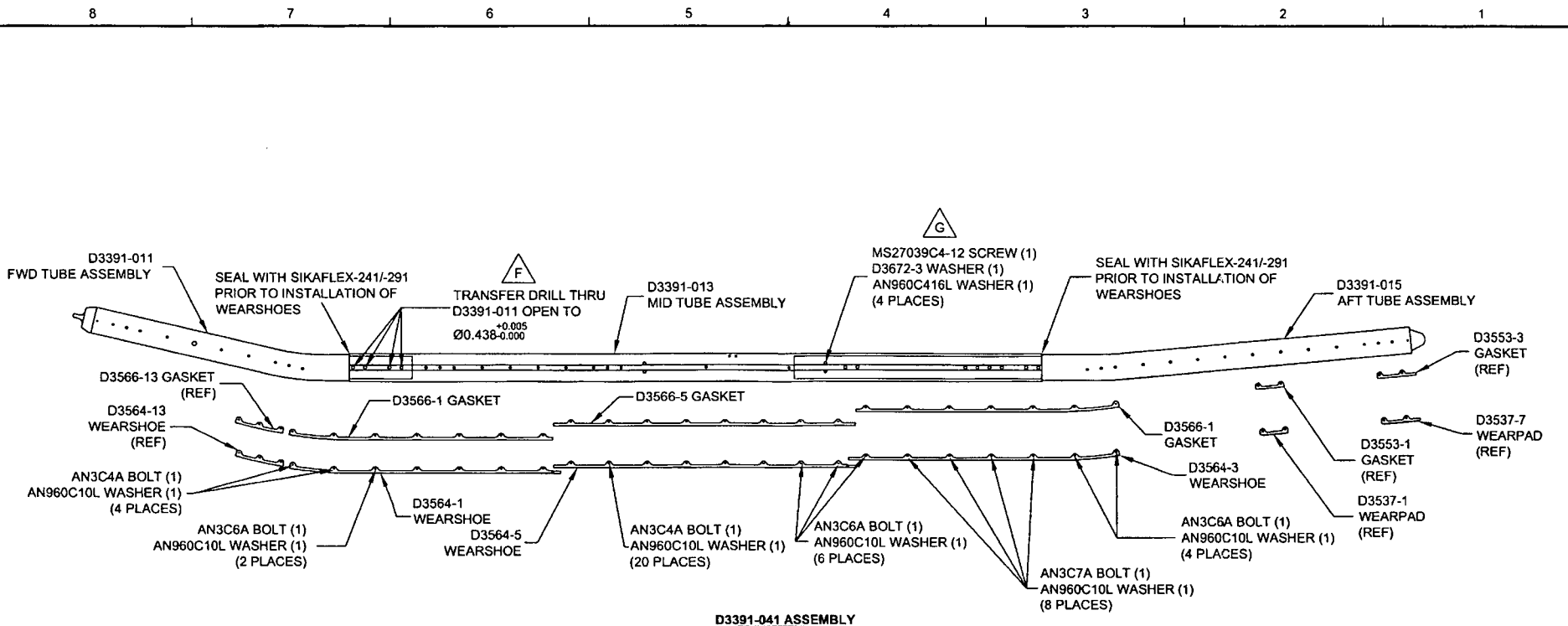
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.501	✓			
88.93	+/-0.030	88.945	✓			
44.995	+/-0.030	44.995	✓			
3.200	+/-0.010	3.195	✓			
1.526	+0.000/-0.030	1.520	✓			
0.200	+/-0.010	0.201	✓			
7.500	+/-0.010	7.500	✓			
27.750	+/-0.010	27.760	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.299	✓			
0.200	+/-0.010	0.200	✓			
3.520	+/-0.010	3.513	✓			
0.687	+0.010/-0.000	0.690	✓			
R0.062	+/-0.010	0.062	✓			
Ø0.484	+0.005/-0.001	0.487	✓			

<b>Measured by:</b> J.F. / BC	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/11/22	<b>Date:</b> 07/12/05	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM [Signature]	[Signature]



**D3391-041 ASSEMBLY**

RELEASED  
07-11-87

**D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C418L	WASHER

**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH  
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH  
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS  
OFF POWDER COATING WITH MEK DEGREASER.  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.

G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.31		

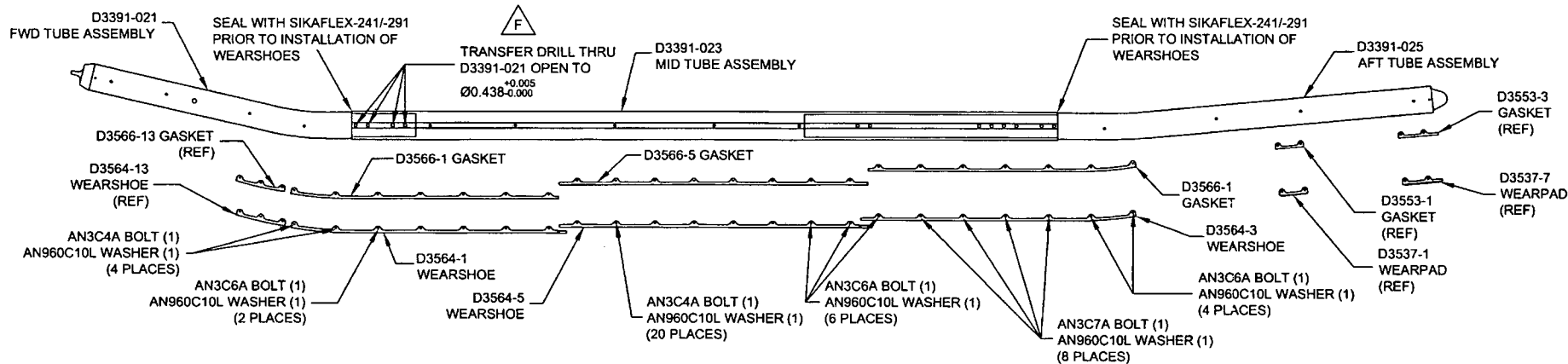
**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA

DRAWING NO. D3391  
REV. G  
SHEET 1 OF 8

TITLE 412 FLOAT SKIDTUBE  
SCALE NTS

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NO 355776  
WORK ORDER



**D3391-043 ASSEMBLY**

**RELEASED**  
07.11.94

**D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

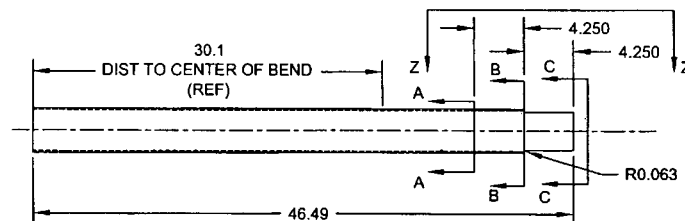
QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

**GENERAL NOTES**

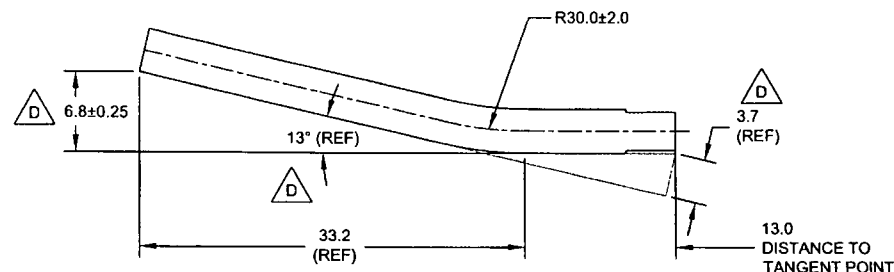
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH  
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH  
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS  
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL  $\varnothing 0.297$  SIZE HOLES  
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	JFC	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JP	D3391	SHEET 2 OF 8
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	412 FLOAT SKIDTUBE	NTS
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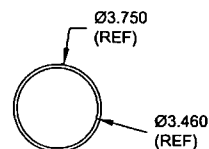
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NO. 35776



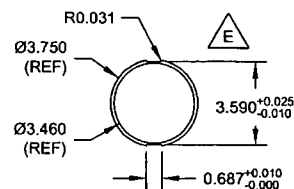
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



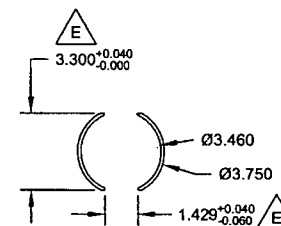
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



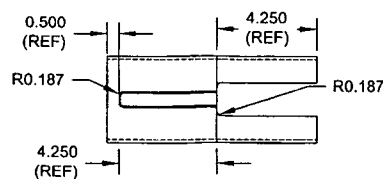
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(SCALE 1:5)



**SECTION B-B**  
(SCALE 1:5)



**SECTION C-C**  
(SCALE 1:5)



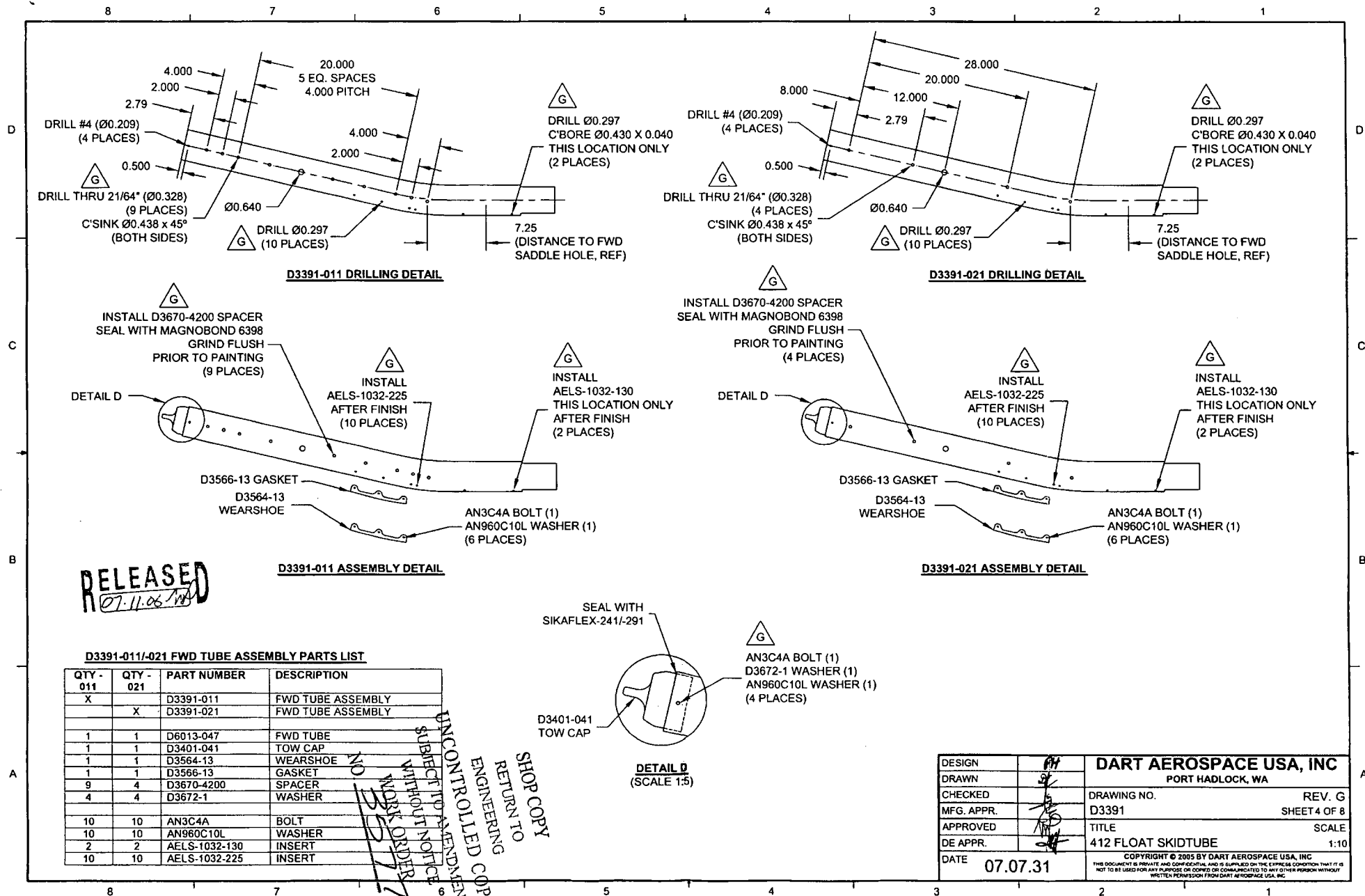
**VIEW Z-Z**  
(SCALE 1:5)

RELEASED  
07-11-28 147

NO. 35776  
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DRAWN	JJC	PORT HADLOCK, WA
CHECKED		DRAWING NO. D3391
MFG. APPR.		REV. G SHEET 3 OF 8
APPROVED		TITLE 412 FLOAT SKIDTUBE
DE APPR.		SCALE 1:10
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC

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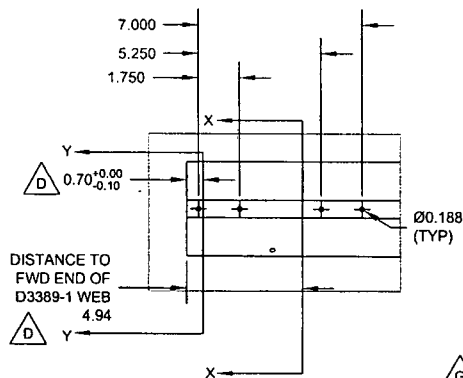
#### D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
2	2	AELS-1032-130	INSERT
10	10	AELS-1032-225	INSERT

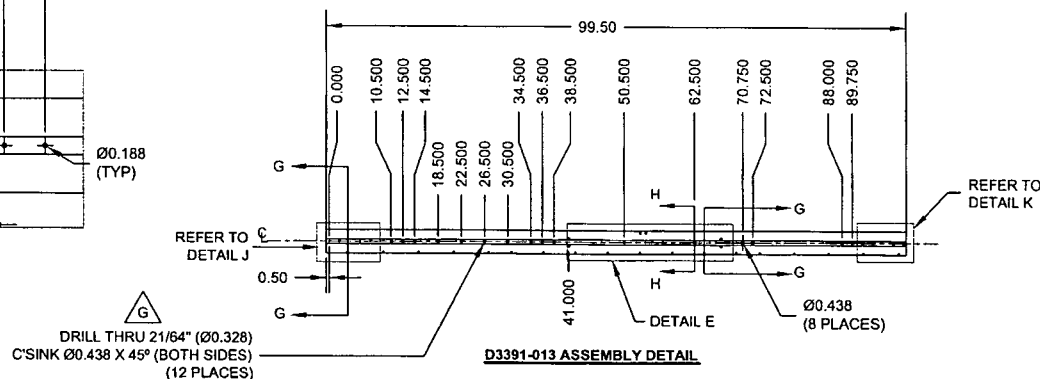
NO WORK ORDER  
SUBJECT TO AMENDMENT  
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DETAIL D  
(SCALE 1:5)

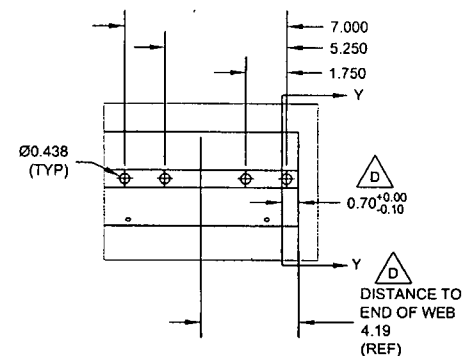
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. G
MFG. APPR.	PH	D3391	SHEET 4 OF 8
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	412 FLOAT SKIDTUBE	1:10
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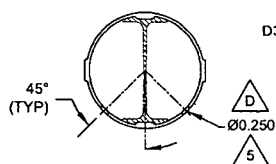
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(SCALE 1:5)



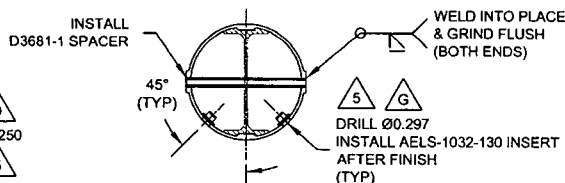
**D3391-013 ASSEMBLY DETAIL**



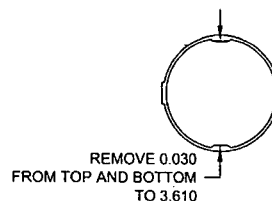
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(SCALE 1:5)



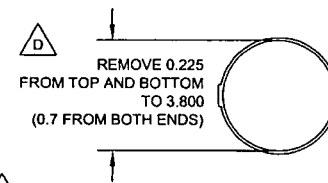
**SECTION G-G**  
(SCALE 1:4)



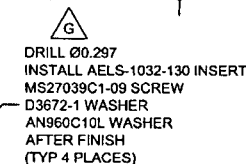
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(SCALE 1:4)



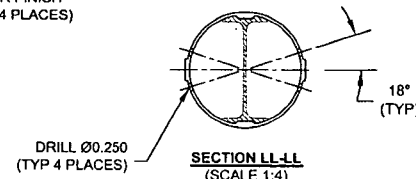
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(SCALE 1:4)



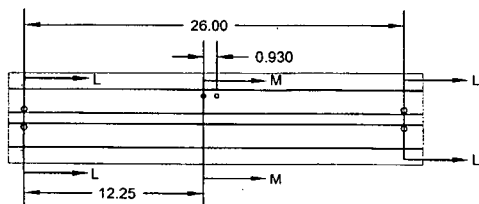
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(SCALE 1:4)



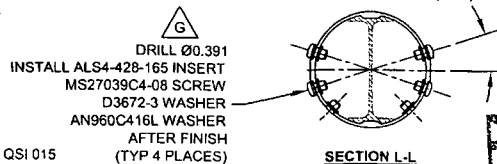
**SECTION M-M**  
(SCALE 1:4)



**SECTION LL-LL**  
(SCALE 1:4)



**DETAIL E**  
(SCALE 1:8)



**SECTION L-L**  
(SCALE 1:4)

**D3391-013 MID TUBE ASSEMBLY PARTS LIST**

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
12	D3681-1	SPACER
4	D3672-1	WASHER
4	D3672-3	WASHER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

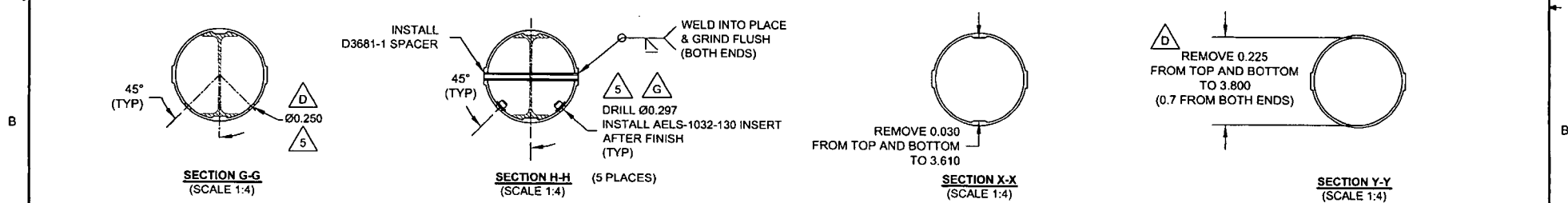
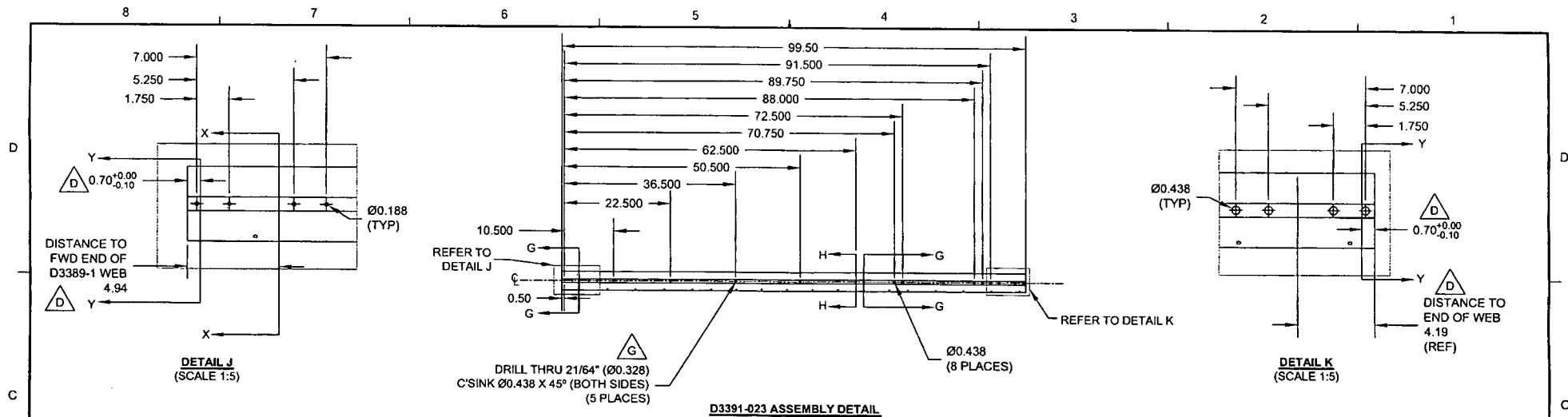
**D3391-013 MID TUBE ASSEMBLY**

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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07-11-2017

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MFG. APPR.		D3391	SHEET 5 OF 8
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**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

**D3391-023 MID TUBE ASSEMBLY**

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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MFG. APPR.	RE	D3391	SHEET 6 OF 8
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